



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2570
Job Sheet 209799



Part No: D2570

Job Qty: 300 pcs

Part Name: Bushing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/8/20

Job Tracking No:

Due Date: 6/1/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP E 02.08.29 Re-format; Removed finishing; Material change KJ IPP F 07.07.06 rev B dwg EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Hardinge - 1	300 pcs	6/1/20	6/1/20	0.50	10.34	Hardinge - 1	DC PML 20/05/24
110	QC 2	300 pcs	6/1/20	6/1/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	PML 20/05/24
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	DAS 33 9.99
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S279130



Part: D2570

Job No: 209799

Serial No/Batch: S279130

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/24/20

120	QC 8	300 pcs	6/1/20	0.00	0.00	QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 2 - 76	
						QC 2 - 86	
						QC 2 - 83	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	DAS
						QC 8 - 33	33 20/05/24
						QC 8 - 35	9-89
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
						QC 8 - 66	
						QC 8 - 73	
						QC 8 - 82	
130	Packaging 3-1 - Stock - B4B	300 pcs	6/1/20	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	

				Packaging 3 - 23 - B4B	DAS 84	54008
				Packaging 3 - 24 - B4B	9-89	
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
				Packaging 3 - 37 - B4B		
140 QC 21 - SA	300 pcs	6/1/20	0.00 0.00	QC 21 - SA - 21	DAS 21	MAY 25 2020
				QC 21 - SA - 70	9-89	
				QC 21 - SA - 53		
				Broussard		
Part Op 100 - (Hardinge)Machine as per folio FA258 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - LOCATION : ST008 140 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M303R0.750	303 Round Bar 0.750	19.8000 ft (.066 ea)	100-Hardinge - 1	3278197 20'		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Hardinge - 1	M303R0.750	20	37	0		
Part Specifications						
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments	
1	Bushing	0.800inches ± 0.010	0.810 0.790	.825		
2	Bushing	0.060inches ± 0.005	0.065 0.055	.0605		
3	Bushing	0.010inches + 0.010 - 0.000	0.020 0.010	.010		
4	Bushing	0.425inches + 0.000 - 0.002	0.425 0.423	.424		
5	Bushing	0.257inches + 0.006 - 0.001	0.263 0.256	.260		
6	Bushing	0.750inches ± 0.010	0.760 0.740	.745		
7	Bushing	0.030inches ± 0.010	0.040 0.020	.03		
8	Bushing	20.000Degrees ± 0.000	20.000 20.000	20		

Plex 5/8/20 2:28 PM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042) _____																													
Description Work Order Deviation				Disposition																															
Completed By				Lead hand / Supervisor																															
				QC / QA Coordinator																															

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																																
Bending	Misaligned/off center	Folio/Program	Outside Tolerance																																
Crushing	BOM/Route	Grain Direction	Drawing																																
Cracks	Broken/Damage/Defect	Weld	Finish																																
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing																																
Marks/Chatter	Drill Holes	Out of Sequence	Misread																																
Mislabeled	Fit/Function	Off-set/Set-up																																	
Other/Details:		_____																																	